

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61727

Tuesday, August 31, 2010 2:42:09 PM



Page 2

Item ID: D2804-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 8/31/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

27 M

10/09/08

0.00

Memo

x2

d

140



Small Fab

Small Fab

Small Fab

Memo

Press Fit D2809 as per Dwg D2804

0.00

0.00

E/S 10/09/13 (2)

150



Small Fab

Small Fab

Small Fab

Memo

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 □2-Assemble as per Dwg D2804.

0.00

0.00

E/S 10/09/13 (2)

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Item ID: D2804-042

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 8/31/2010 Start Qty: 2.00

Required Date: 9/7/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 156

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run

Start



Stop



②

2012

Per 8/31/14 (2)

10/09/14

MK
10-9-14

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Picklist Print

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Page 1

Work Order ID: 61727

Parent Item: D2804-042

Parent Item Name: Bracket Assembly



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30 MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2 Bracket		Manufactured	No			100	Each	11.0000	1	2		8/31/09/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST149				11					
				46613				11					
D2805-2 Stop		Manufactured	No			100	Each	16.0000	1	2		8/31/09/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST024				16					
				46736				8					
				58528				8					
NAS1515H3 Washer		Purchased	No			100	Each	90.0000	4	8		8/31/09/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST277				90					
				111268				90					
AN3C16A Bolt		Purchased	No			150	Each	75.0000	2	4		8/31/09/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST352				75					
				111193				25					
				111425				50					

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Page 2

Work Order ID: 61727



Parent Item: D2804-042



Parent Item Name: Bracket Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 2.00

Required Qty: 2.00

D2809

Manufactured No

150 Each

51.0000

1



Bushing



2
8/31/09/13

Location

Loc Qty

Loc Code

ST025

51

34035

12

46438

1

47733

38

2

MS21043-3

Purchased No

150 Each

2,733.000

2



Nut



4
8/31/09/13

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2657

109147

49

111383

46

112314

2562

4

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Shop Packet Print

Page 2

Dart Aerospace Ltd

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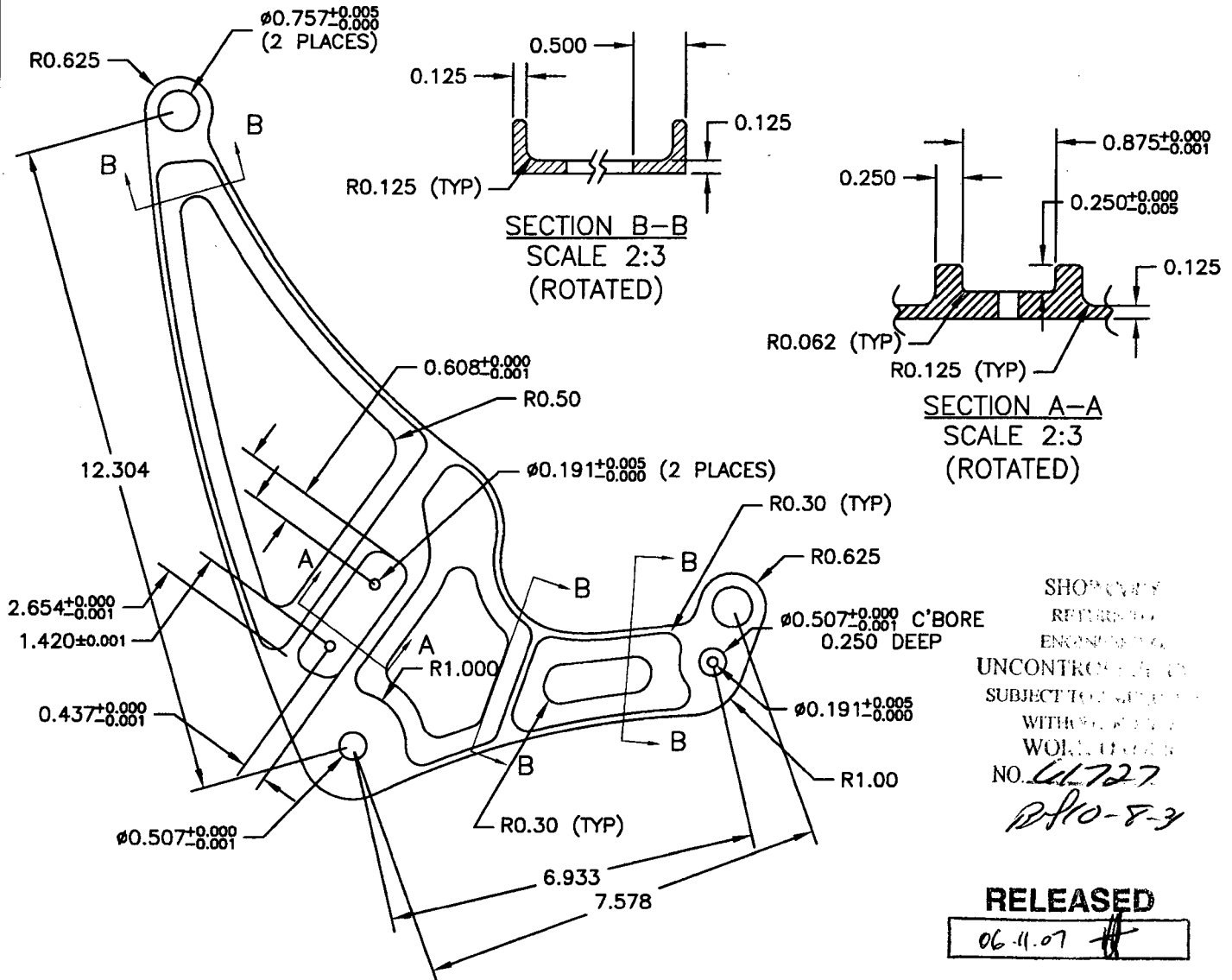
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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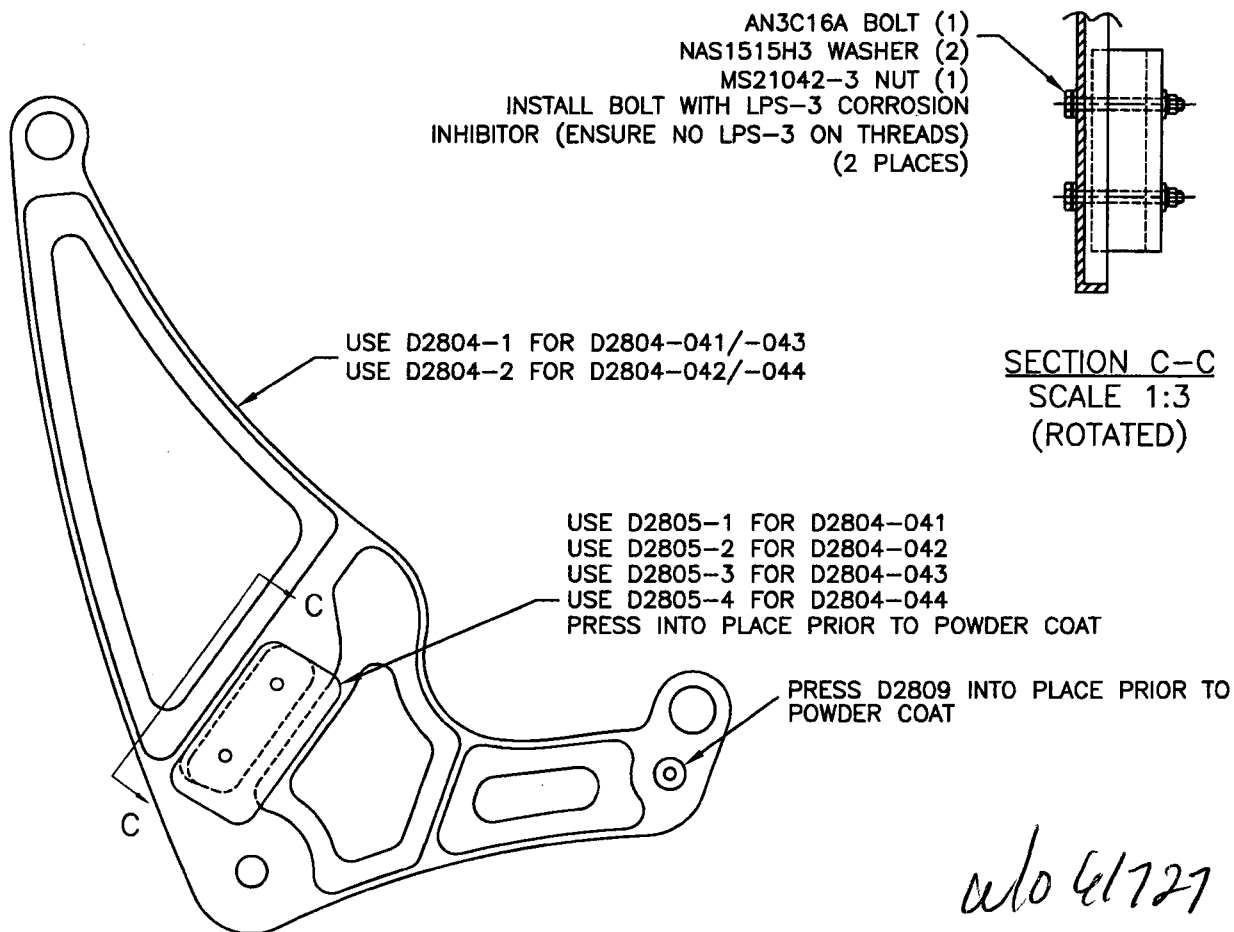
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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